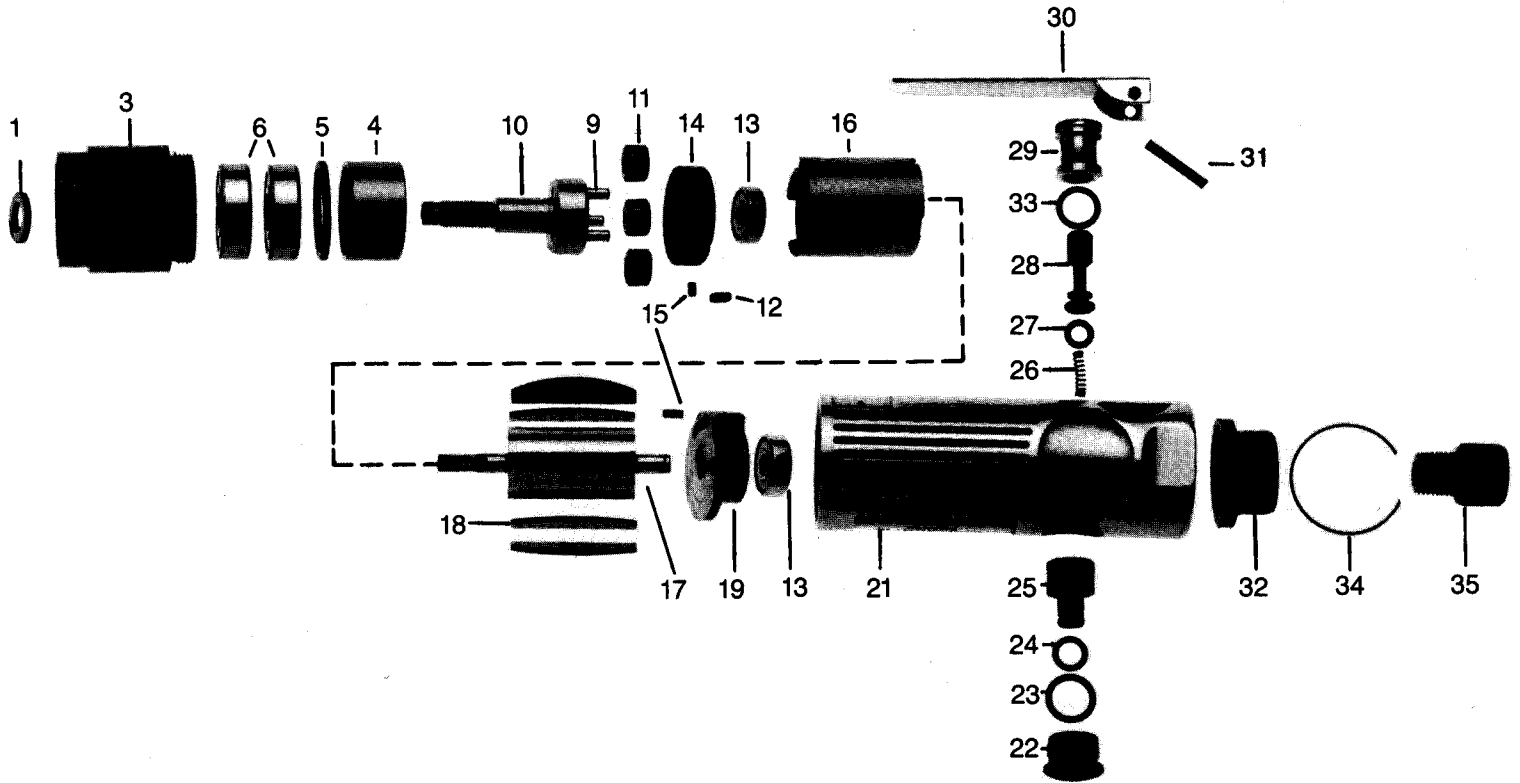




STRAIGHT PNEUMATIC MOTOR
PARTS LIST



253-56 POWER UNIT
S/N 101 & HIGHER

*Use 154-47 Spacer on model PN-1000 Nibbler

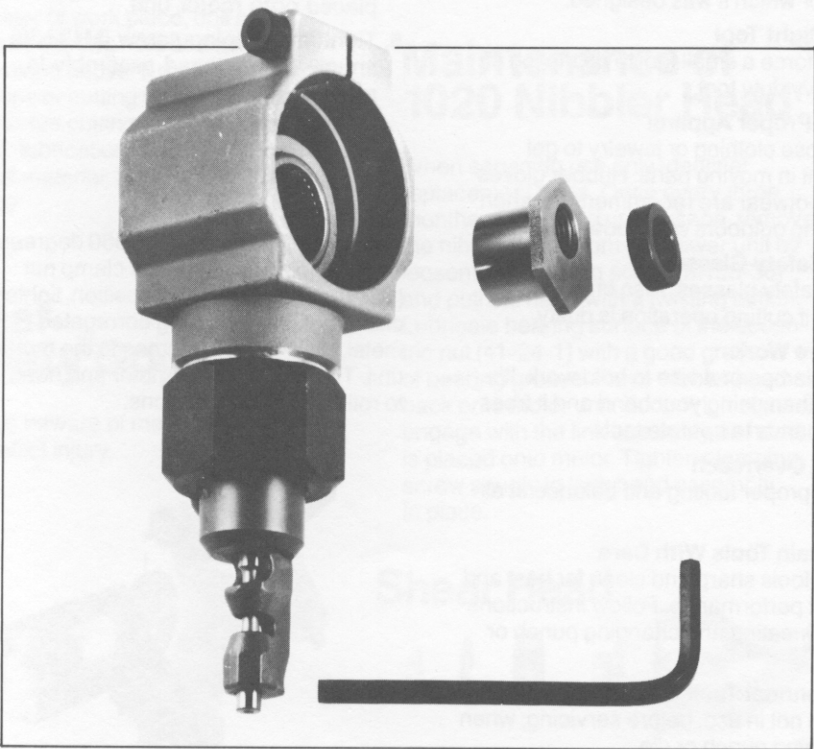
*Use 154-50 Spacer on models P-1060 & P-1080 Shears

Index No.	Part Number	Description	Req'd Tool	Index No.	Part Number	Description	Req'd Tool
1	154-*	Spacer	1	21	820020	Motor Housing	1
3	820002	Clamp Nut	1	22	820021	Retaining Screw	1
4	820003	Internal Gear	1	23	820022	"O" Ring	1
5	820004	Large Spacer	1	24	820023	"O" Ring	1
6	820005	Ball Bearing	2	25	820024	Air Regulator	1
9	820008	Planet Pin	3	26	820025	Spring	1
10	820009	Planet Spindle	1	27	820026	"O" Ring	1
11	820010	Planet Gear & Bushing	3	28	820027	Throttle Valve	1
12	820011	Key	1	29	820028	Valve	1
13	820012	Ball Bearing	2	30	820029	Throttle Leaver	1
14	820013	Front End Plate	1	31	820030	Lever Pin	1
15	820014	Pin	2	32	820031	Exhaust Deflector	1
16	820015	Cylinder	1	33	820032	"O" Ring	1
17	820016	Rotor	1	34	820033	Retaining Clip	1
18	820017	Rotor Blade	4	35	820034	Inlet Bushing	1
19	820018	Rear Plate	1				

KETT

Model 1020 Nibbler Attachment

Safety, Operation and Maintenance



Fits all KETT Shear motors and is also interchangeable with other 40-20 and 60-20 compatible shear heads.

Safety Rules

Keep Work Area Clean—Beware of Metal Chips

Cluttered areas and benches invite accidents. Metal chips may inflict injury.

Keep Children Away

All visitors should be kept a safe distance from work area.

Store Idle Tools

When not in use, tools should be stored in dry, high or locked-up place—out of reach of children.

Don't Force Tool

It will do the job better and safer at the rate for which it was designed.

Use Right Tool

Don't force a small tool to do the job of a heavy duty tool.

Wear Proper Apparel

No loose clothing or jewelry to get caught in moving parts. Rubber gloves and footwear are recommended when working outdoors when power is electric.

Use Safety Glasses

Use safety glasses. Also face or dust mask if cutting operation is dusty.

Secure Work

Use clamps or a vise to hold work. It's safer than using your hand and it frees both hands to operate tool.

Don't Overreach

Keep proper footing and balance at all times.

Maintain Tools With Care

Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing punch or dies.

Disconnect Tools

When not in use; before servicing; when changing punch or die.

Remove Adjusting Keys and Wrenches

Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.

Avoid Accidental Starting

Don't carry connected tool with finger on trigger. The tool should be used only for the purpose for which it is designed.

Read Operating Instructions Carefully.

Assembly

To assemble Nibbler Head (1020) onto drive motor.

1. Insert spacer (154-47 or 154-57) onto shaft of motor.
2. Turn eccentric nut (41-24-1) onto shaft with hex side toward motor and against spacer.
3. Lubricate bearing surface of eccentric nut (41-24-1) with a good grade of bearing grease.
4. Place nibbler head onto motor unit. Eccentric nut (41-24-1) must engage with link assembly (1024) as head is placed onto motor unit.
5. Tighten clamping screw (M133-36) snugly to lock head assembly in place.

Adjustments

The die (1021) rotates a full 360 degrees. To change position, loosen clamp nut (1029), set die in desired position, tighten clamp nut. When cutting corrugated metal, set die at 90 degrees to the motor unit. This will allow the motor and head to roll with the corrugations.



Motor Units

Operating Instructions

Please read carefully all safety rules and operating instructions.

The 1020 Nibbler Head is recommended for CR sheet steel up to 18 gauge. Secure work piece. To start cut, place die opening of nibbler slightly onto the edge of the work piece to steady the tool and ready it for the cut. Depress the trigger switch on the drive motor and guide the nibbler into the work. Don't force it. Avoid double thickness of material which exceed the 18 gauge recommended capacity. For cutting within perimeter of work piece, drill a 1/2" diameter starting hole and follow instructions above. If resistance to tool develops or cutting becomes difficult, discontinue cutting and check the following: lubrication; chip clogging; thickness of material; sharpness of punch and die.

Wear Safety Goggles

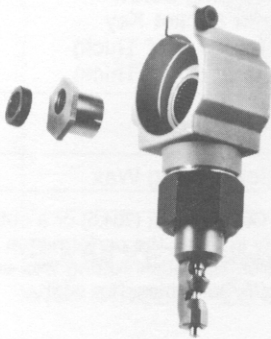
Always beware of metal chips which may inflict injury.

To Change Punch and/or Die

1. Disconnect motor unit from power source.
2. Remove clamp nut (1029) and the die (1021) will slide off.
3. Remove retainer nut (1027) and the punch (1022) will slide out of the head.
4. Insert new punch (1022) into head and secure with retainer nut (1027).
5. Insert new die (1021) and secure with clamp nut (1029).

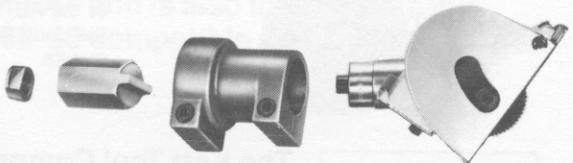
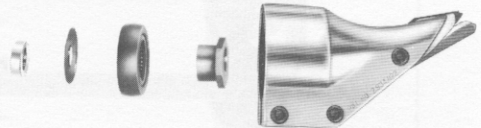
Maintenance of 1020 Nibbler Head

When servicing use only identical replacement parts. Once every three months, depending upon usage, remove the nibbler head from the power unit by loosening clamping screw (M133-36) and pull the head with a twisting action. Lubricate bearing surface of the eccentric nut (41-24-1) with a good grade of bearing grease. Place nibbler head back onto motor unit. Eccentric nut must engage with the link assembly as head is placed onto motor. Tighten clamping screw snugly to lock head assembly in place.



Nibbler Head

Shear Head



Saw Head

Model 1020 Nibbler Attachment



Spacer _____
see note on spacer
envelope for proper
thickness and record
number

1020 Parts List

41-24-1	Eccentric Nut
1021	Die
1022	Punch
1023	Nibbler Housing
1024	Link Assembly
1025	Pin
1026	Plunger
1027	Retainer Nut
1028	Brass Sleeve
1029	Clamp Nut
M133-36	Clamping Screw
M150-9	4mm Socket Key
154-47	Spacer (.181" Thick)
154-57	Spacer (.142" Thick)

NOT SHOWN

264-5	Stick Cutting Wax
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The use of Stick Cutting Wax (264-5) or a cutting oil will greatly improve the performance of the KETT Nibbler. Use stick cutting wax on the underside of the work piece for best results.



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